

001756



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 173050



Part No: D350-591-311

Job Qty: 40 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/23/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	3/21/18	0.00	0.00		Start Up Large Fab-4		GL
110	Large Fab	10 pcs	3/22/18	0.00	9.91		Large Fab 2		CP
120	QC	10 pcs	3/22/18	0.00	0.00		QC9		PD 18-3-5
130	QC	10 pcs	3/22/18	0.00	0.00		QC5		PD 18-3-5
140	HandFinish	10 pcs	3/22/18	0.00	1.84		HandFinish1		18-03-05 SA
150	QC	10 pcs	3/22/18	0.00	0.00		QC7-2		CP
180	Large Fab	10 pcs	3/22/18	0.00	9.91		Large Fab 2		18-3-6
190	QC	10 pcs	3/22/18	0.00	0.00		QC10		38 DAS
200	QC	10 pcs	3/22/18	0.00	0.00		QC5		38
210	HandFinish	10 pcs	3/22/18	0.00	1.84		HandFinish1		SA 18-03-07
220	Powdercoat	10 pcs	3/22/18	0.00	2.90		Powdercoat1		BE 18-3-13
230	HandFinish	10 pcs	3/23/18	0.00	1.84		HandFinish3		18-03-13
240	QC	10 pcs	3/23/18	0.00	0.00		QC3		38
250	Packaging	10 pcs	3/23/18	0.00	0.00		Packaging1-3		MAR 21 2018
260	QC	10 pcs	3/23/18	0.00	0.00		QC4		
265	DC	10 pcs	3/23/18	0.00	0.00		DC		
270	Packaging	10 pcs	3/23/18	0.00	0.00		Packaging3-1		
280	QC21-FG	10 Ea	3/23/18	0.00	0.00		QC21		MAR 27 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M138673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M138673 6-Grind End Plate flush 7-Install last rivet as per Dwg

220 - START TIME: _____ OVEN TEMPERATURE: 320° FINISH TIME: _____

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084



Container No: S046941



Part: D350-591-311

Job No: 173050

Serial No/Batch: S046941

Revision:
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

S046941x9xLH

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	9041204
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	9046942 9046943
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	9046940
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	9046553
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	9048132 9046540 80
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	9048055(10) 9036202 10
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	9025738
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	23	0
	D3219-1	20	44	0
	D3272-1	10	0	0
180-Large Fab	D3065-041	10	12	0
	D3066-1	20	30	0
	MS20600-AD4W4	160	1,841	0
250-Packaging	AN3-35A	20	122	0
	AN4-13A	80	467	0
	AN5-36A	20	148	0
	D2230-3	40	65	0
	D2618	20	234	0
	D2856-400-720	20	97	0
	D3235-1	20	14	0
	D3278-041	10	8	0
	MS21042L3	20	3,411	0
	MS21042L4	80	998	0
	MS21042L5	20	877	0
	NAS1149D0363J	40	3,425	0
	NAS1149D0463J	160	2,258	0
	NAS1149D0563J	40	1,330	0

Part Specifications

Specifications could not be found.

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Container No: S046941



Part: D350-591-311

Job No: 173050

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Date: 03/06/18

Master Unit 001466



Job No 173050



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001756	S038696	AN3-35A	Bolt	S017089	ST348	2
001756	S052584	AN3-35A	Bolt	s017089	ST348	16
001756	S038695	AN4-13A	Bolt	S027722	ST344	8
001756	S049072	AN4-13A	Bolt	S035984	PKG	2
001756	S052585	AN4-13A	Bolt	s045860	ST344	56
001756	S038694	AN5-36A	Bolt	S014157	ST336	2
001756	S052580	AN5-36A	Bolt	s041116	ST336	16
001756	S052597	D2230-3	Mounting Lug	S049159	ST521	36
001756	S038699	D2618	Bushing	S025116	ST008	2
001756	S052590	D2618	Bushing	s043411	ST008	16
001756	S038698	D2856-400-720	Abrasion Strip 4" X 7.20"	S037326	ST418	2
001756	S049089	D2856-400-720	Abrasion Strip 4" X 7.20"	S035936	PKG	4
001756	S052594	D2856-400-720	Abrasion Strip 4" X 7.20"	s037326	ST418	12
001756	S052595	D3235-1	Mounting Lug	S049171	ST522	18
001756	S048828	D3278-041	Support Assembly	S048826	ST522	8
001756	S038692	MS21042L3	Nut	S037284-1	FP001	2
001756	S052579	MS21042L3	Nut	s038764	ST303	16
001756	S038691	MS21042L4	Nut	S016351	ST303	8
001756	S052578	MS21042L4	Nut	s045901	ST303	64
001756	S038690	MS21042L5	Nut	S016880	ST303	2
001756	S052577	MS21042L5	Nut	s016880	ST303	16
001756	S038689	NAS1149D0363J	Washer	S015269	ST263	4
001756	S052568	NAS1149D0363J	Washer	s015269	ST263	32
001756	S038688	NAS1149D0463J	Washer	S014733	ST263	16
001756	S052567	NAS1149D0463J	Washer	s045845	ST263	128
001756	S038686	NAS1149D0563J	Washer	S025743	ST263	4
001756	S052566	NAS1149D0563J	Washer	s025743	ST263	32

S053036X

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.